

Work Order ID 75521

75521

Page 1

October-24-11 1:00:39 PM

Item ID: D350-636-013

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH

Start Date: 24/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								
IIN-D350-636	I								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-013 CHG 006

JB Schulze JG MLJ 12-4-20

B75521

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 75521

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Item ID: D350-636-013

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N900040100

Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube LH

Start Date: 24/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & DT886A for first side only DT886B for second side (detail B)								
	7- Clecko DT886B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)								
	9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10- Open up holes of Detail A to 0.297" (total of 2 holes per side)								

12/04/05

Dart Aerospace Ltd

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 Start Date: 24/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
 from bending as per QSI 004
 A/R Aluminum Rod batch: *m120164* *BE 2/04/10*

12-Grind welds flush as per Dwg D2750

120
120
 QC
 Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00
 Memo 0.00

130
130
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O 0.00
 Memo 0.00

3/16/12-4-10

S. L. L. L.

S. L. L. L.

Dart Aerospace Ltd

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/10/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 07/11/2011 **Req'd Qty:** 1.00 *** 1 ***

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Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

Dart Aerospace Ltd

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Item Name: Skidtube LH

Start Date: 24/10/2011 Start Qty: 1.00 ***1***

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Required Date: 07/11/2011 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 12/08/13
exp. date: 12/08/13

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10)

A/R Aluminum Rod batch: M120854 *OE 12/04/12*

8-Grind welds flush as per Dwg D2750 *OE 12/04/12*

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

B 12/04/11

116/12-413
12/04/13

12/04/16
12/04/16

Dart Aerospace Ltd

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Required Date: 07/11/2011 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

2/6 12-4-17 BL.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	✓		M-L 12/04/18
200									
Powdercoat		0.00							
Powder Coating	Memo START TIME: 9:00 OVEN TEMPERATURE: 320°F FINISH TIME: 9:30								
210	QC3- Inspect Part Finish	0.00				164	✓		all ulosir
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								
220	HandFinishing	0.00				164	✓		all ulosir
220									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								

m121134

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Start Date: 24/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>AA 121221</u> EXP DATE: <u>13101</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>AA 110348</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>AA 114591</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

1 hH d Munlog/18

512/4/19

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NS1

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NS2

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Start Date: 24/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

12/04/2011

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

8/7/12

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-013

Reo 72

12/4/00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 75521***75521***

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Revision ID:

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Item Name: Skidtube LH

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1

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Required Date: 07/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/4/23

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H02.09.25Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L
 10.06.22 revise seq110 DD verf:EC IPP Rev:M 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	40.0000	1				
D2600-3-BENT									**				
Extrusion Bent													

Location	Loc Qty	Loc Code
LG	40	
66873	8	
73253	3	
75021	9	
75022	10	
75023	10	

D3493-1
D3493-1
 Washer

Manufactured No 110 Each 51.0000 2

**

Location	Loc Qty	Loc Code
ST062	51	
70697	13	
71846	38	

D2739
D2739
 350 I Beam

Manufactured No 160 Each 5.0000 1

**

Location	Loc Qty	Loc Code
LG	5	
72155	2	
72156	1	
72157	2	

1 12/04/05
 78835 JB 12/04/20
 1 12/04/10

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D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

160 Each

59.0000

1 1

D2744

Cap

**

BE 12/04/10
B 78900

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

46

71861

46

D3490-1

Manufactured No

160 Each

26.0000

4 4

D3490-1

Cross Bolt Spacer

**

BE 12/04/12
B 81976

Location

Loc Qty

Loc Code

LG

24

67773

5

71841

19

LG001

2

62450

2

D3490-5

Manufactured No

160 Each

36.0000

4 4

D3490-5

Cross Bolt Spacer

**

BE 12/04/12

Location

Loc Qty

Loc Code

LG001

36

59230

36

4

Dart Aerospace Ltd

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D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

220 Each

167.0000 8 8

D2743

Crossbolt Spacer

**

Location

Loc Qty

Loc Code

LG

109

71839

45

73403

64

LG001

58

67766

4

68251

54

ALS4-1032-225

Purchased No

230 Each

2,601.000 38 38

ALS4-1032-225

Insert

**

Location

Loc Qty

Loc Code

ST281

2601

108696

749

110768

62

118386

860

118966

930

AN3C5A

Purchased No

230 Each

1,316.000 34 34

AN3C5A

Bolt

**

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1309

116419

28

117343

110

117764

169

117872

2

118451

500

119127

500

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Shop Packet Print

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Dart Aerospace Ltd

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Parent Item Name: Skidtube LH

75521

D350-636-013

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

224.0000

4

4

AN3C6A

BOLT

**

11120693 (x1) HU 12/04/11

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

223

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

168

AN6C44A

Purchased

No

230

Each

105.0000

4

4

AN6C44A

BOLT

**

11120465 (x1) HU 12/04/11

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

103

118387

33

118985

40

119125

30

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

111.0000

1

1

AN8C35A

BOLT

**

21 11/04/11

Location

Loc Qty

Loc Code

FP

75

117511

9

118286

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332

R

Purchased

No

230

Each

0.0000

38

38

***AN960C10I ***

washer

D2745

Manufactured

No

230

Each

149.0000

8

8

D2745

Bushing

**

x11121255 (x38) 21 11/04/11

**

1381964 (x8) 21 11/04/11

Location

Loc Qty

Loc Code

FP-A

1

69529

1

ST021

148

71835

148

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 75521

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

75521

D350-636-013

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

17.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

B377021 (x1) JH 12/04/11

Location

Loc Qty

Loc Code

FP

7

69903

7

FP007

1

61689

1

FP008

9

67788

1

71887

8

D3492-1

Manufactured No

230

Each

142.0000

8

8

D3492-1

Plug

**

B381963 (x8) JH 12/04/11

Location

Loc Qty

Loc Code

FP

142

69531

8

73402

54

74444

80

D3492-5

Manufactured No

230

Each

32.0000

8

8

D3492-5

Plug

**

B377044 (x8) JH 12/04/11

Location

Loc Qty

Loc Code

FP

32

70698

32

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-25	Manufactured	No	230	Each	15.0000	1	1	
D3535-25								
Wearshoe								

**

B80331 (x1) ul n/ou/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP018	15	
62233	1	
73424	2	
74592	12	

D3536-25	Manufactured	No	230	Each	45.0000	1	1	
D3536-25								
Gasket								

**

B78902 (x1) ul n/ou/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	45	
74526	7	
74595	12	
75039	26	

D3537-1	Manufactured	No	230	Each	55.0000	3	3	
D3537-1								
Wearpad								

**

B73716 (x3) ul n/ou/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	48	
74597	48	
FP017	7	
69817	5	
70686	2	

D3631-1	Manufactured	No	230	Each	91.0000	8	8	
D3631-1								
Washer								

**

B75548 (x8) ul n/ou/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST072	91	
68062	91	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75521

75521

Parent Item: -D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each 26.0000 1 1

D3791-1

Wearplate

**

B78897 (x1) M n/oxlr

Location	Loc Qty	Loc Code
FP017	26	
62239	2	
74527	12	
74598	12	

D3793-1 Manufactured No

230 Each 19.0000 1 1

D3793-1

Wearshoe

**

B78901 (x1) M n/oxlr

Location	Loc Qty	Loc Code
FP001	6	
73422	6	
FP018	13	
74591	13	

D3793-3 Manufactured No

230 Each 11.0000 1 1

D3793-3

Wearshoe

**

B78935 (x1) M n/oxlr

Location	Loc Qty	Loc Code
FP001	11	
74593	11	

D3794-1 Manufactured No

230 Each 52.0000 1 1

D3794-1

Gasket

**

B80435 (x1) M n/oxlr

Location	Loc Qty	Loc Code
FP014	52	
74529	12	
74594	12	
75042	28	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230

Each

34.0000

1

1

D3794-3

Gasket

**

B80436(x1) M nlog1/

Location

Loc Qty

Loc Code

FP002

34

73423

6

74530

14

74596

14

MS21043-6

Purchased

No

230

Each

497.0000

4

4

MS21043-6

NUT

**

M nlog1/

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

477

112314

267

117887

10

118384

200

MS21083C8

Purchased

No

230

Each

86.0000

1

1

MS21083C8

NUT

X has to be

**

M126142(x1) M nlog1/

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

4

118077

4

ST303

81

115884

0

118354

6

118614

50

119309

25

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

345.0000

1

1

NAS1149C0832R

WASHER

**

12/04/11

Location

Loc Qty

Loc Code

FP-B

17

114915

17

ST297

328

114915

328

NAS1515H3L

Purchased

No

230

Each

103.0000

4

4

***NAS1515H3L ***

WASHER

**

11/20/360 (x4) 12/04/11

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

63

113362

57

118686

6

NAS1611-005

Purchased

No

230

Each

144.0000

8

8

NAS1611-005

O-RING

**

11/19/438 (x8) 12/04/11

Location

Loc Qty

Loc Code

FP002

144

106099

39

114220

105

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

89.0000

8

8

NAS1611-010

O-RING

**

Handwritten: 12/04/11

Location

Loc Qty

Loc Code

FP

65

Handwritten: 11120986

Handwritten: X6

117460

8

118077

1

118612

56

FP-A

24

110915

14

Handwritten: 11120770

Handwritten: X2

119307

10

AN8C21A

Purchased

No

260

Each

65.0000

2

2

Handwritten: ✓

AN8C21A

BOLT

**

Handwritten: 120094 23

Location

Loc Qty

Loc Code

ST343

65

118045

15

118758

50

D2741

Manufactured

No

260

Each

17.0000

1

1

Handwritten: ✓

D2741

Blade, 350 Skidtube

**

Handwritten: 76984 23 12/04/20

Location

Loc Qty

Loc Code

ST466

17

70667

17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 75521

75521

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH

Start Date: 24/10/2011

Required Date: 07/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

260 Each

804.0000 8 8 ✓

D3672-1

Phenolic Washer

**

JB

Location

Loc Qty

Loc Code

FP-A

444

52505

0

66821

444

166821

ST074

360

72229

360

MS21083C8

Purchased No

260 Each

86.0000 2 2 ✓

MS21083C8

NUT

**

12104 JB

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

4

118077

4

ST303

81

115884

0

118354

6

118614

50

119309

25

NAS1149D0863J

Purchased No

260 Each

226.0000 2 2 ✓

NAS1149D0863.J

WASHER

**

JB 12/04/20

Location

Loc Qty

Loc Code

ST298

226

118078

126

119307

100

119307

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOWN BY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO ASSAULT M.C.J.

11/10/24

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 1 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

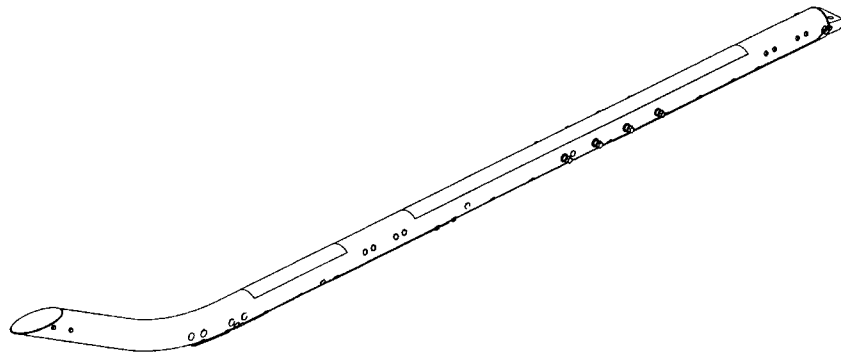
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

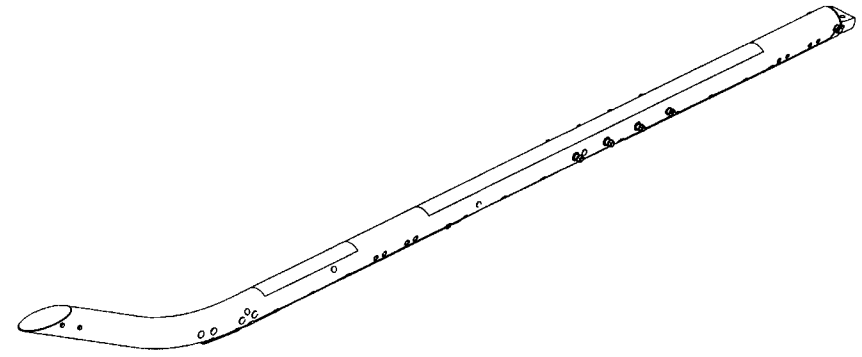
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75521



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
8-9-22

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 2 OF 11
APPROVED	AM	TITLE	SCALE
DE APPR	AM	350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

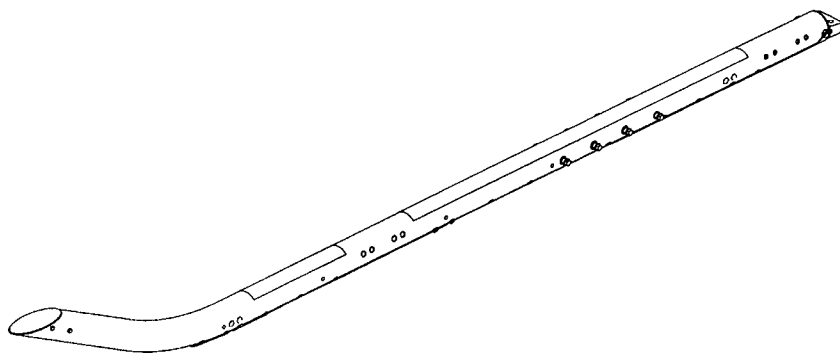
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

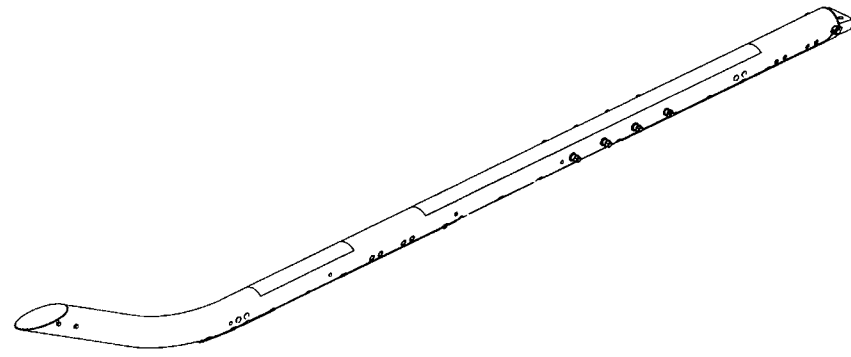
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75521



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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64-9-22/111

DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

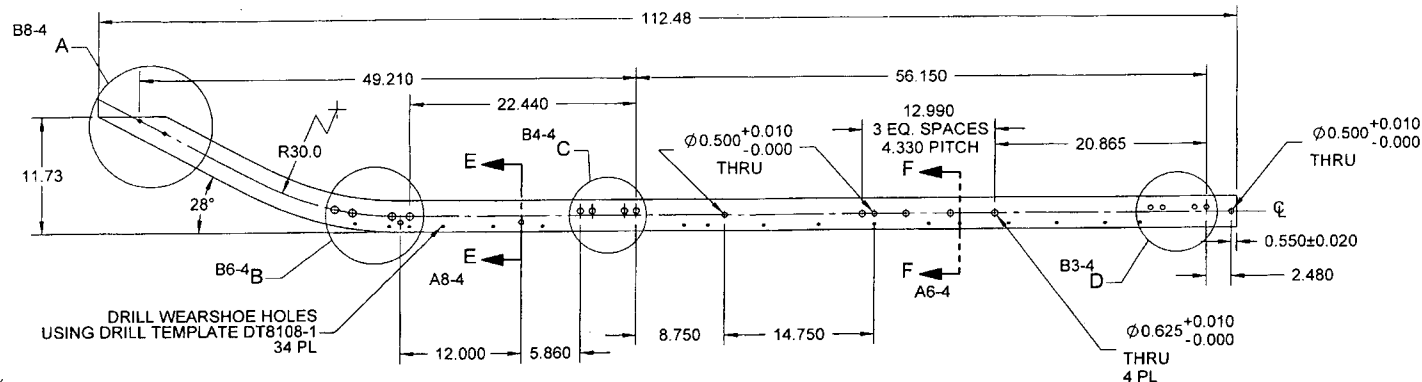
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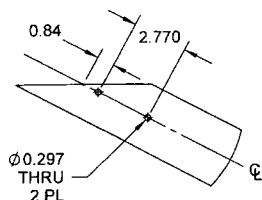
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

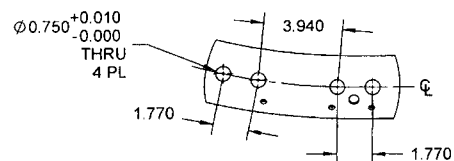
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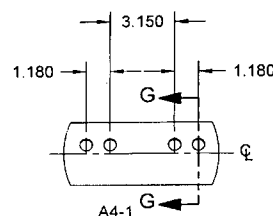
D2750-1 LH SKIDTUBE



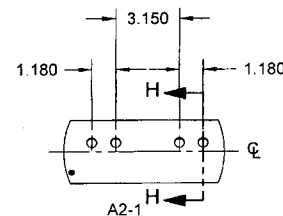
DETAIL A
SCALE 2X



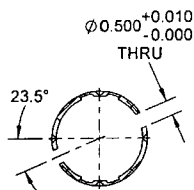
DETAIL B
SCALE 2X



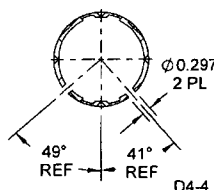
DETAIL C
SCALE 2X



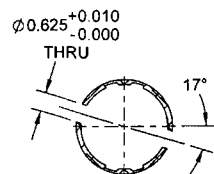
DETAIL D
SCALE 2X



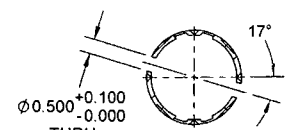
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

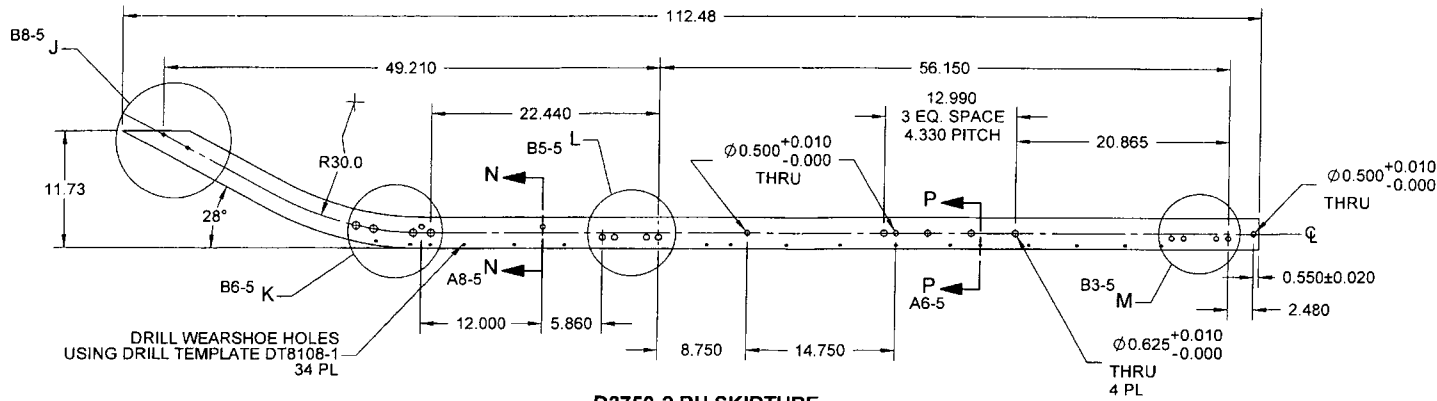
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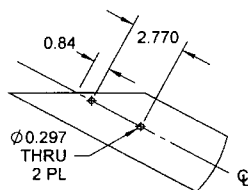
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

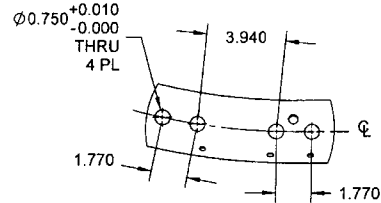
75521



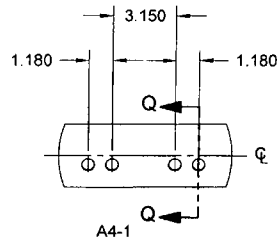
D2750-2 RH SKIDTUBE



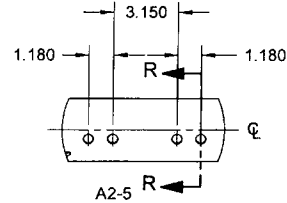
DETAIL J
SCALE 2X



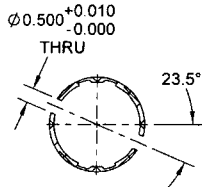
DETAIL K
SCALE 2X



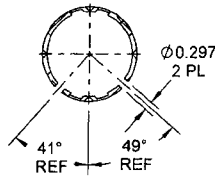
DETAIL L
SCALE 2X



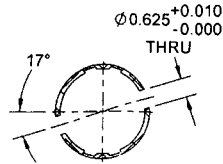
DETAIL M
SCALE 2X



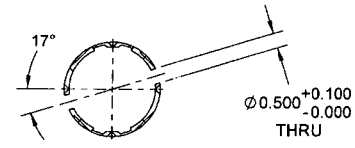
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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08-22-11

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

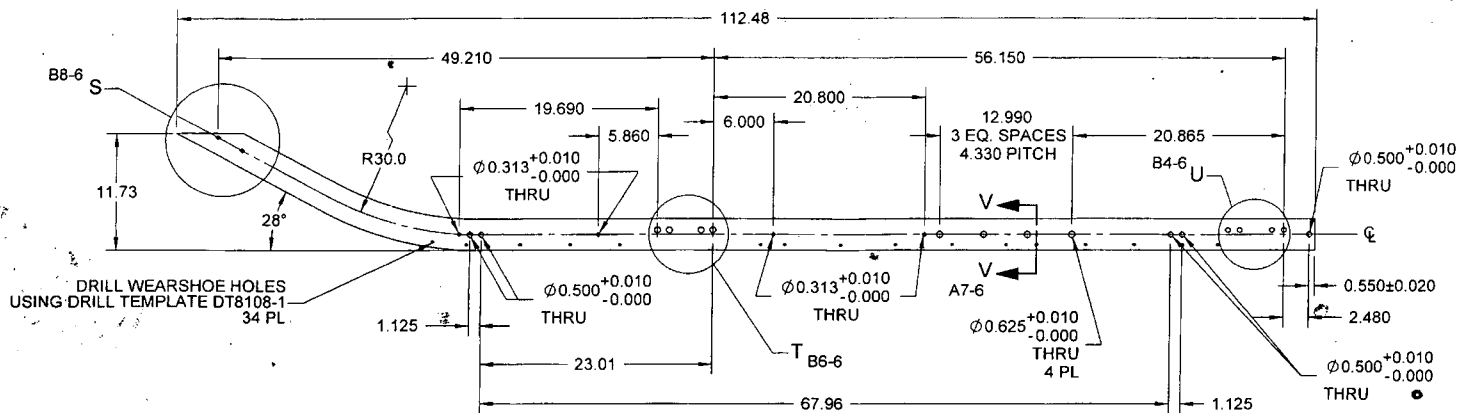
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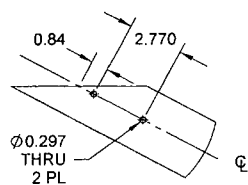
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

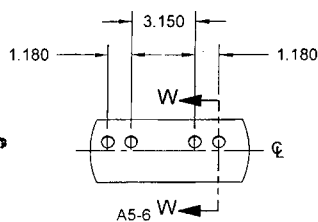
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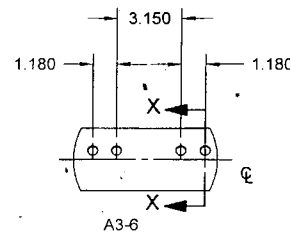
D2750-3 LH SKIDTUBE



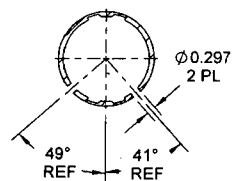
DETAIL S
SCALE 2X



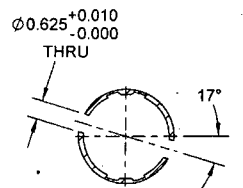
DETAIL T
SCALE 2X



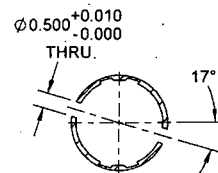
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
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DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

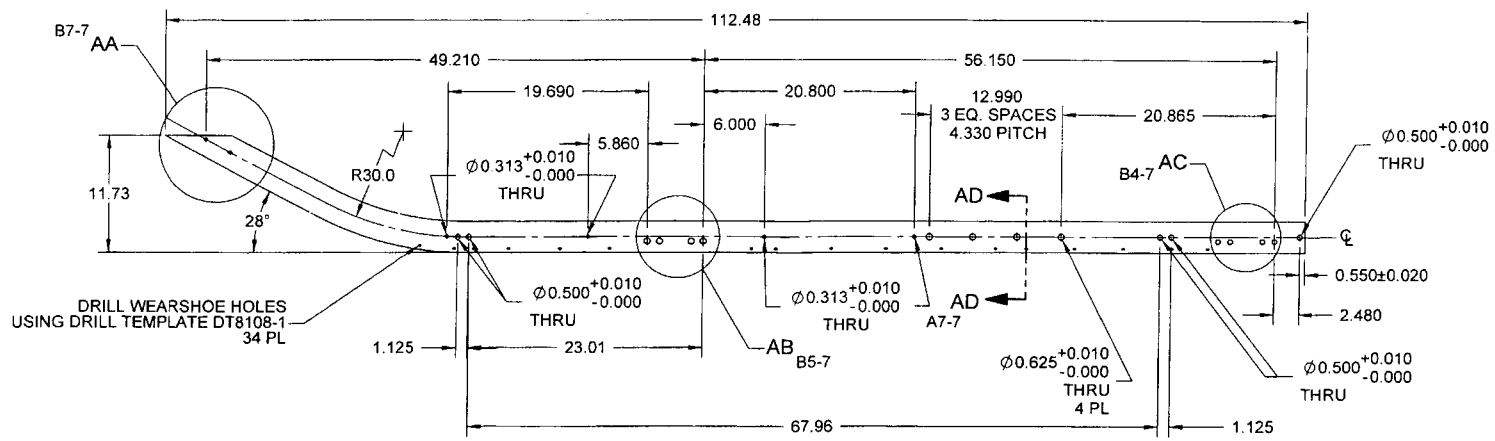
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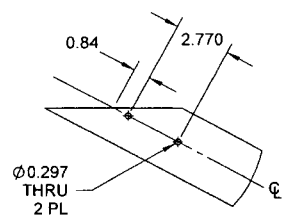
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

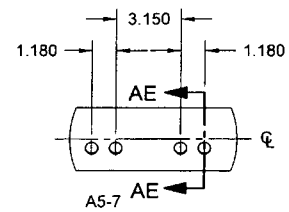
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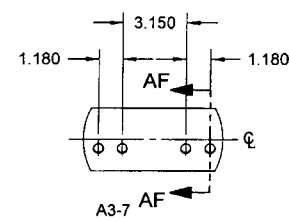
D2750-4 RH SKIDTUBE



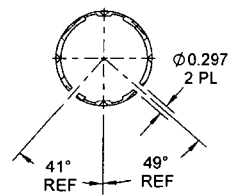
DETAIL AA
SCALE 2X



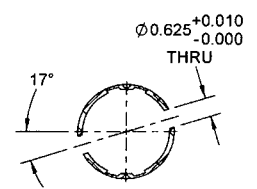
DETAIL AB
SCALE 2X



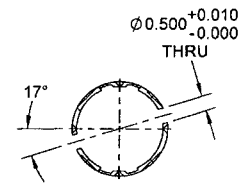
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
06-09-22-118

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE		08.07.16	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

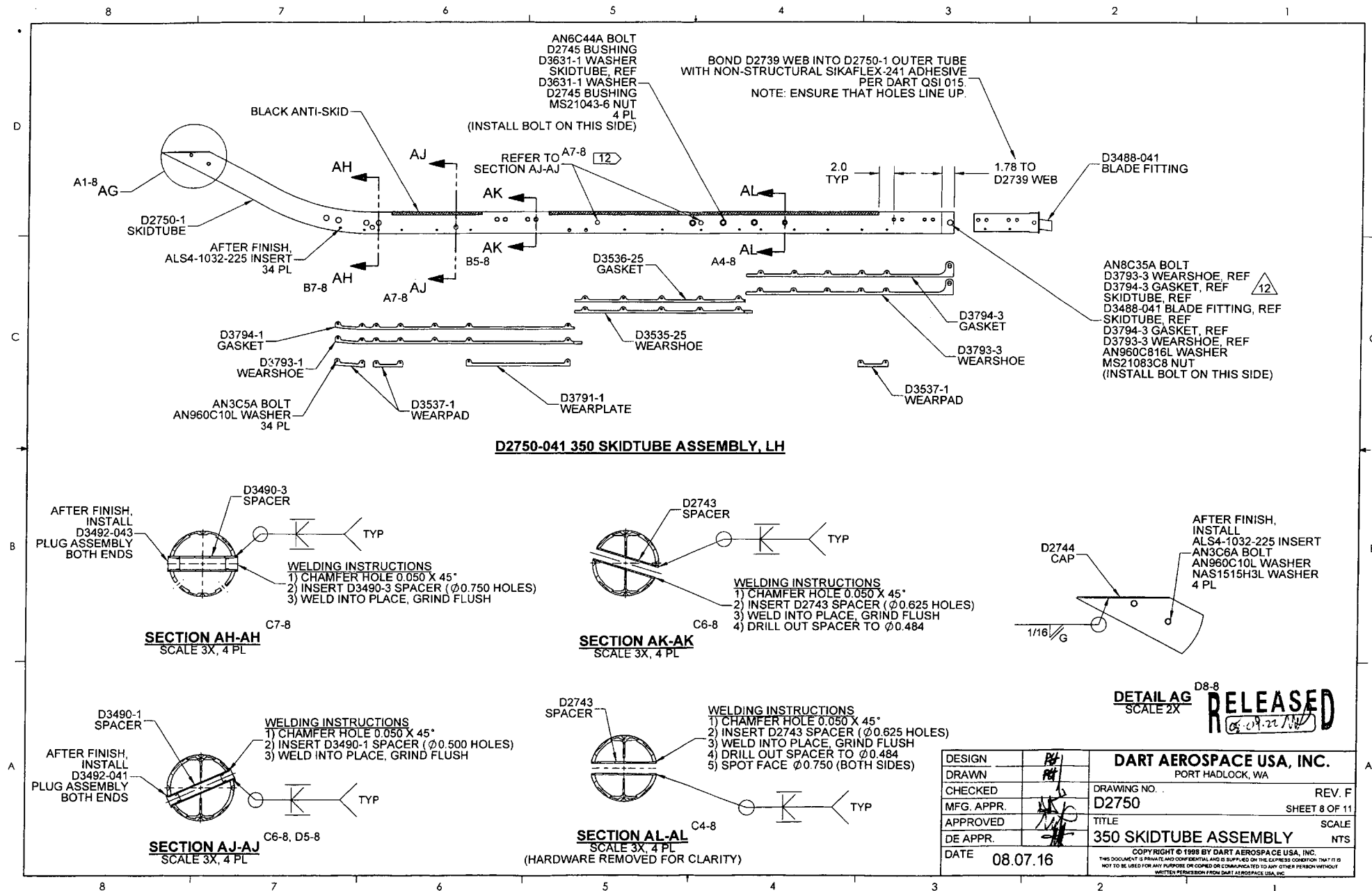
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	REV. F	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS <small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>
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CHECKED	REV. F	
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APPROVED	REV. F	
DE APPR.	REV. F	
DATE	08.07.16	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

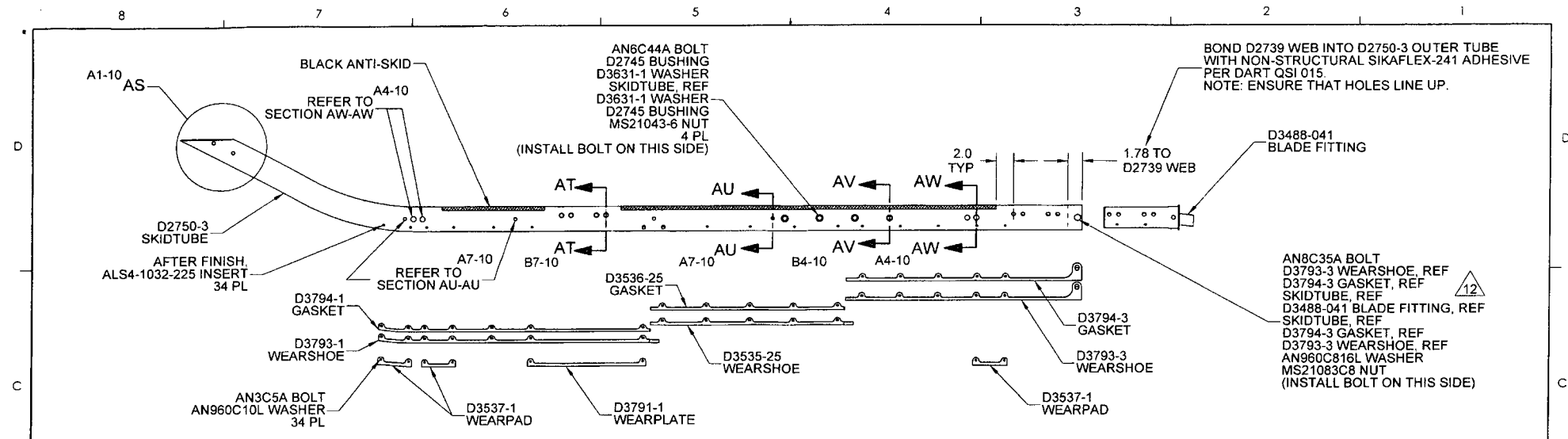
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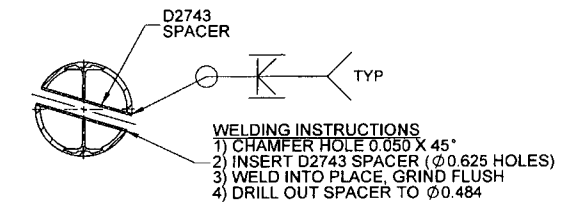
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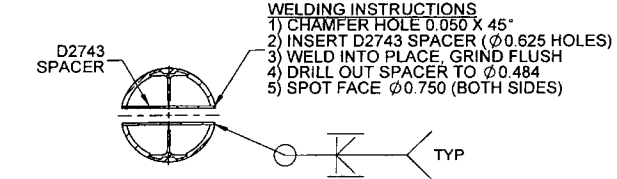
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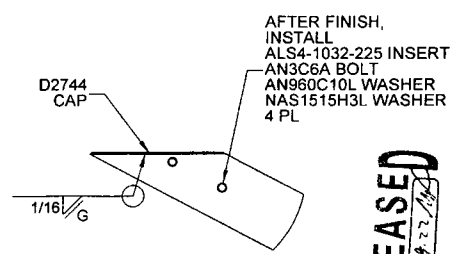
D2750-043 350 SKIDTUBE ASSEMBLY, LH



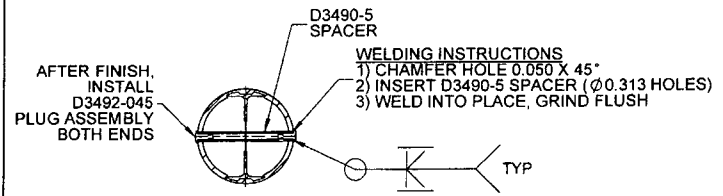
SECTION AT-AT
SCALE 3X, 4 PL



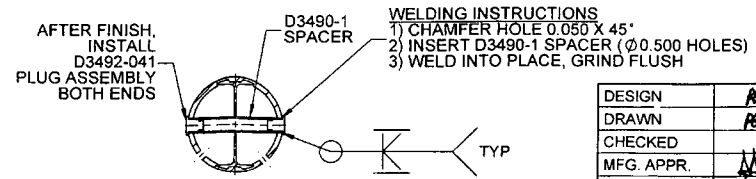
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AS
SCALE 2X



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

DESIGN	AS	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 10 OF 11
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08-22-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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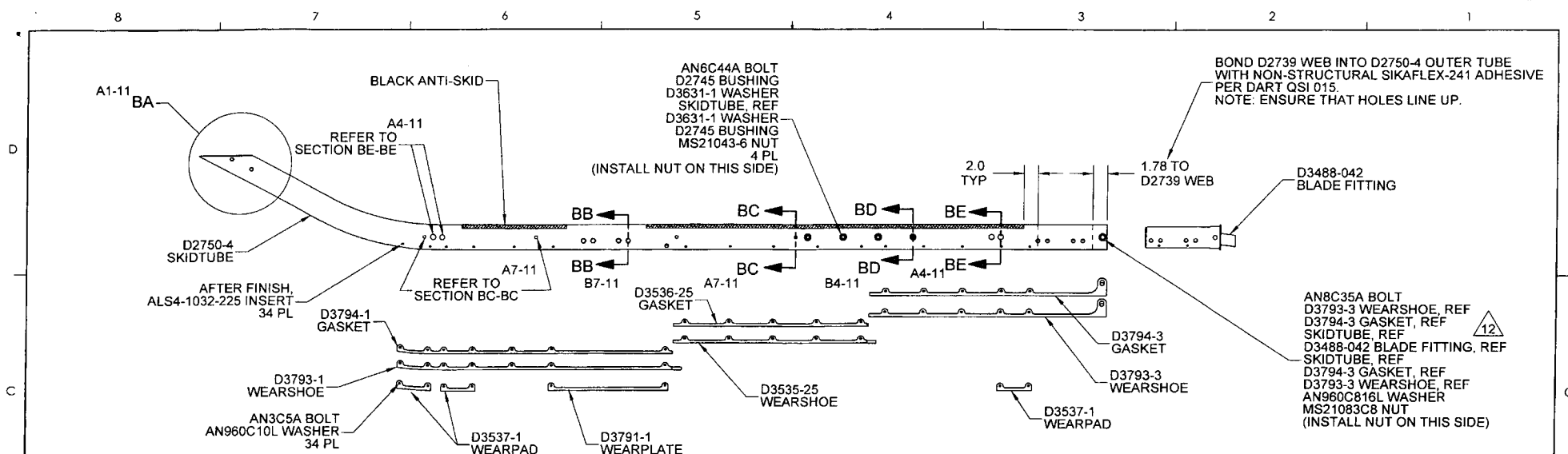
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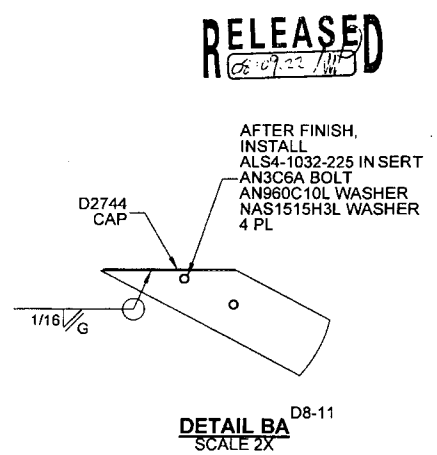
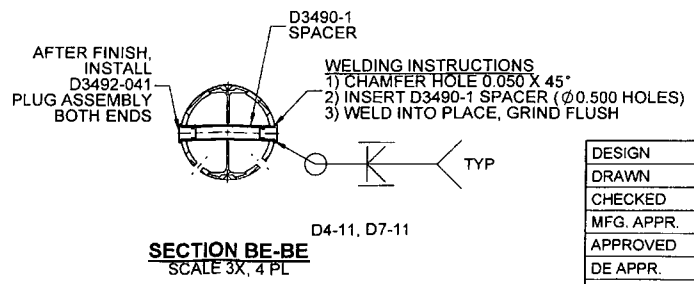
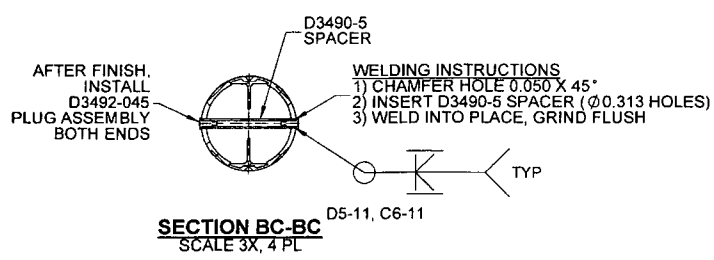
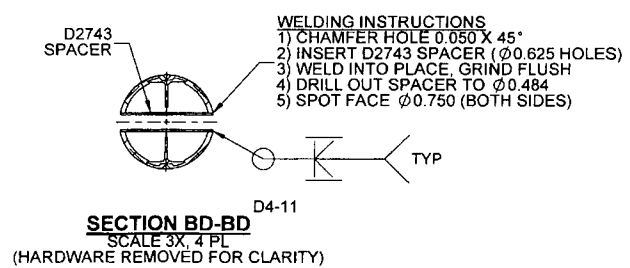
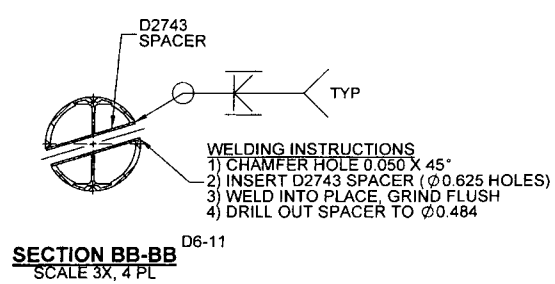
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D2750-044 350 SKIDTUBE ASSEMBLY, RH



DESIGN	75521	DART AEROSPACE USA, INC.	
DRAWN	75521	PORT HADLOCK, WA	
CHECKED	75521	DRAWING NO.	REV. F
MFG. APPR.	75521	D2750	SHEET 11 OF 11
APPROVED	75521	TITLE	SCALE
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 289

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 81400
Part number: 1350-636-016
Description: Shielding
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier David Sewel

Date of Test Coupon 12.04.17

Welder Barclay Elliott

Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld